

Work Order ID 58530

May 10, 2010 12:36:12 PM



Page 1

Item ID: D2849-2

Accept



Setup Start



Revision ID:

Stop



Item Name: End Bracket

Start Date: 10/05/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 14/05/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 10-5-10

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2849

Rev A

100

0.00



SHEAR

Shear

Memo

0.00

Shear

blanks: 3.8"

2.8 10/05/16

10

[Signature]

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1- Machine per Folio D2849-2
2- Deburr and Tumble

2.8 10/05/16

10

[Signature]

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

2.8 10/05/16

10

[Signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 58530

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Page 2

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Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

125

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

DIP 10/05/17

130

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

10-5-18

for SD

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/25

MF 10-5-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

May 10, 2010 12:36:16 PM

Page 1

Work Order ID: 58530



Parent Item: D2849-2



Parent Item Name: End Bracket

Start Date: 10/05/2010

Required Date: 14/05/2010

Comments: IPP B 98.12.07 Changed folio DM

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
M6061T6B2.500X01.50 0		Purchased	No			100	f	36.0000	0.3208			



6061-T6 Bar 2.50 x 1.50

Location

Loc Qty

Loc Code

MAT

36

16742

36

~~16747~~

.3.1666

S.F 10/05/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	58530
Description: End Bracket		Part Number:	D2849-2
Inspection Dwg: D2849	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.55	+/-0.010	3.552	✓			
0.189	+/-0.010	.197	✓			
3.170	+0.000/-0.030	3.161	✓			
1.720	+0.000/-0.030	1.712	✓			
0.97	+/-0.030	.97	✓			
0.178	+/-0.010	.172	✓			
0.10	+/-0.030	.095	✓			
30°	+/-0.5°	30°	✓			
1.10	+/-0.030	1.10	✓			
2.15	+/-0.030	2.153	✓			
1.00	+/-0.030	1.006	✓			
0.125	+/-0.010	.123	✓			
0.375	+/-0.010	.373	✓			
1.775	+/-0.010	1.775				
1.075	+/-0.010	1.075				
36.8	+/-0.5°	36.8	✓			
0.125	+/-0.010	.135				
0.750	+/-0.010	.749	✓			
0.125	+/-0.010	.135				
R0.25	+/-0.030	R.25	✓			
Ø0.257	+0.006/-0.001	.258				
R0.400	+/-0.010	.400				
0.600	+/-0.010	.606	✓			
13°	+/-0.5°	13°				

Measured by:	L.B.
Date:	10/05/16

Audited by:	DJP
Date:	10/05/17

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.10.01	New Issue	KJ	

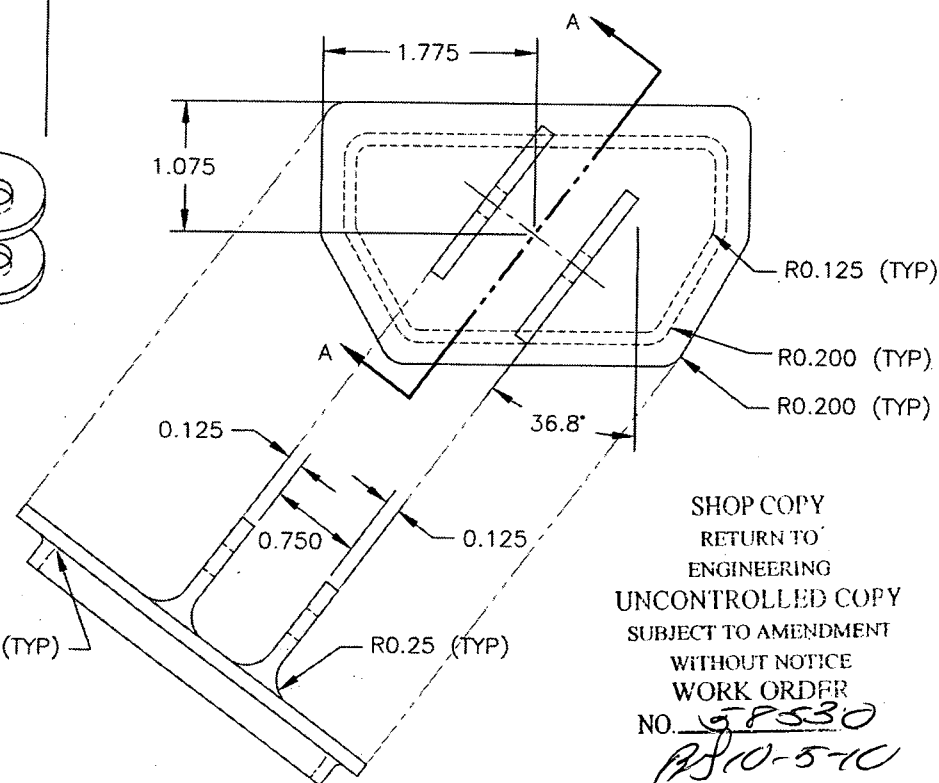
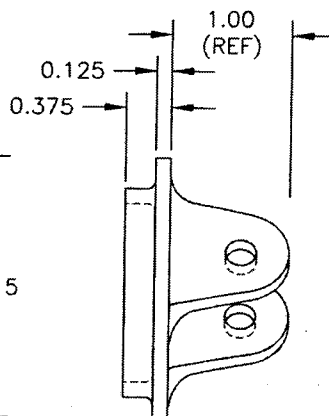
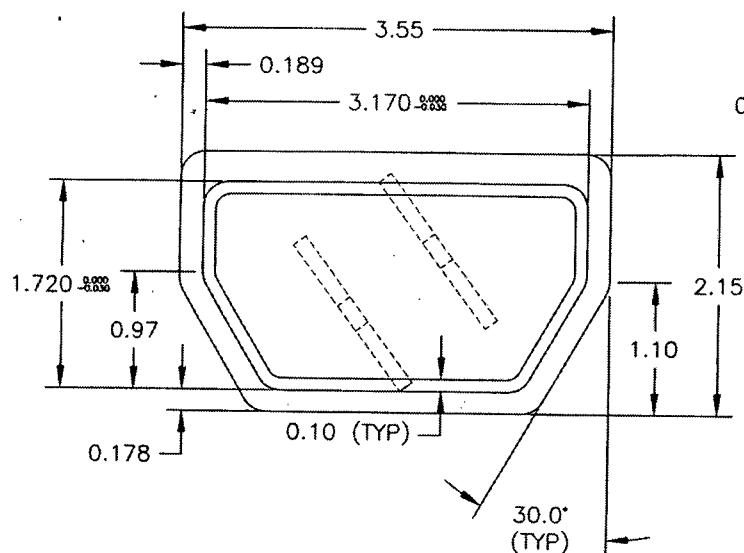
W/O:		WORK ORDER CHANGES					
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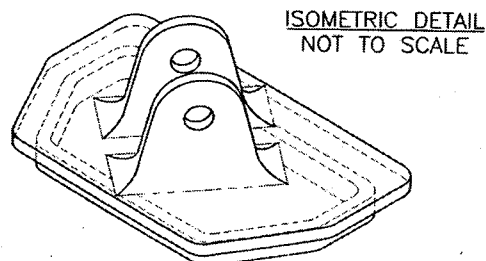
NOTE: Date & initial all entries



R0.063 (TYP)

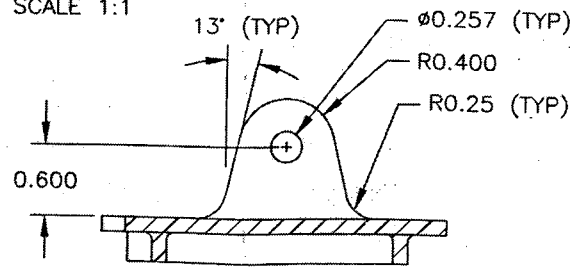
D2849-1 (SHOWN)
D2849-2 (OPPOSITE)
MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)
FINISH: NONE
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 58530
PS10-510



ISOMETRIC DETAIL
NOT TO SCALE

SECTION A-A
SCALE 1:1



RELEASED
98.11.25 KE



A	98.11.10	NEW ISSUE, REPLACES D2358 REV. B AND D2359 REV. A
DESIGN	DRN. BY	DART DART AEROSPACE LTD HAMPSHIRE, ONTARIO, CANADA
CHECKED KE	APPROVED DIT	DRAWING NO. D2849
DATE 98.11.10	TITLE LOW FLOAT STEP END BRACKET	REV. A SHEET 1 OF 1 SCALE 1:1

W/O:		WORK ORDER CHANGES					
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